

Work Order ID 73318

Wednesday, August 31, 2011 10:50:37 AM



Page 1

Item ID: D3536-15

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: *Mkt*

Date: 11-09-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	Memo	0.00	11-09-01	66
D3536	Rev A	FLOW WATER JET			
100		Waterjet	0.00		
		Memo	0.00		
		I-Cut as per Dwg D3536			
		Dwg Rev: <i>A</i>			
		Prog Rev: <i>A</i>			
		Deburr if necessary			
110		QC2- Inspect parts off machine FAI/FAIB	0.00	10-11-09-29	
		Memo	0.00		
		Quality Control			
120		QC8- Inspect parts - second check	0.00	<i>Counted</i> <i>Swartz</i> <i>(x26)</i>	
		Memo	0.00		
		Quality Control			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Gasket	Part Number:	D3536-15
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15	\	X	T	R301
35.65	+/-0.030	35.65	\	X	T	
33.65	+/-0.030	33.65	X		T	
30.15	+/-0.030	30.15	\	X	T	
24.90	+/-0.030	24.90	\	X	T	
19.65	+/-0.030	19.65	\	X	T	
14.40	+/-0.030	14.46	X		T	
9.15	+/-0.030	9.15	\	X	T	
5.65	+/-0.030	5.65	X		T	
3.90	+/-0.030	3.90	X		T	
8.00	+/-0.030	8.00	O		T	
16.00	+/-0.030	16.00	O		T	
24.00	+/-0.030	24.00	Z		T	
0.30	+/-0.030	-301	X		V	R302
0.30	+/-0.030	301	Z		V	
1.89	+/-0.030	1.884	X		V	
Ø0.19	+0.005/-0.001	.190	Z		V	

Measured by: PR	Audited by: S	Prototype Approval: N/A
Date: 11-9-29	Date: 11/09/29	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	SJM

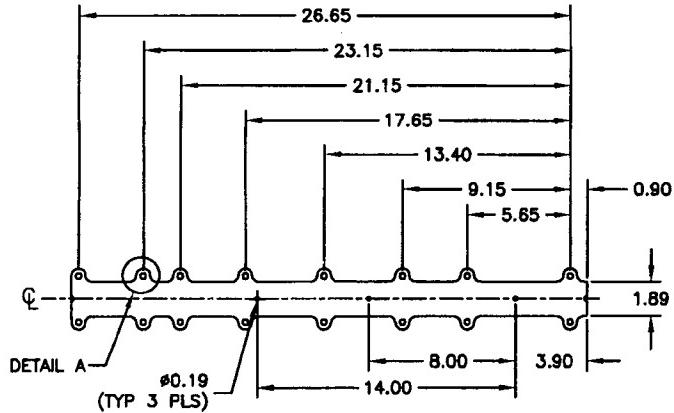
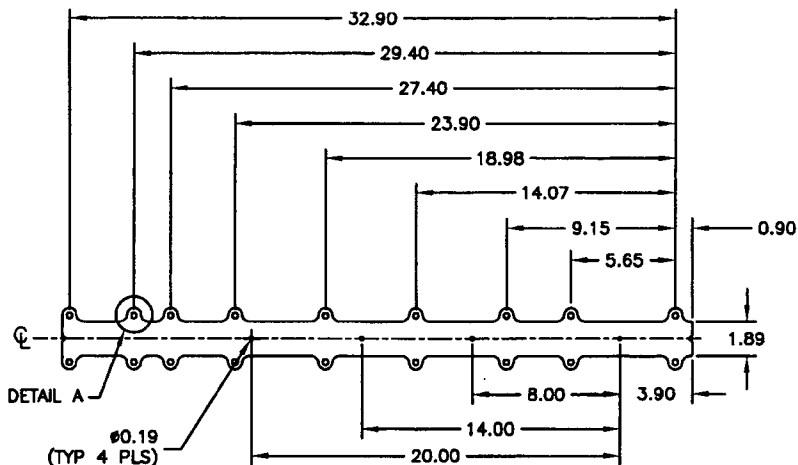
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTDRAFT
04.02.12**D3536-11 GASKET****D3536-13 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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DESIGN C.B	DRAWN BY C.B	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED M	APPROVED M	DRAWING NO. D3536
DATE 06.10.25		SHEET 1 OF 6
A	06.10.25	SCALE 1:10
	NEW ISSUE	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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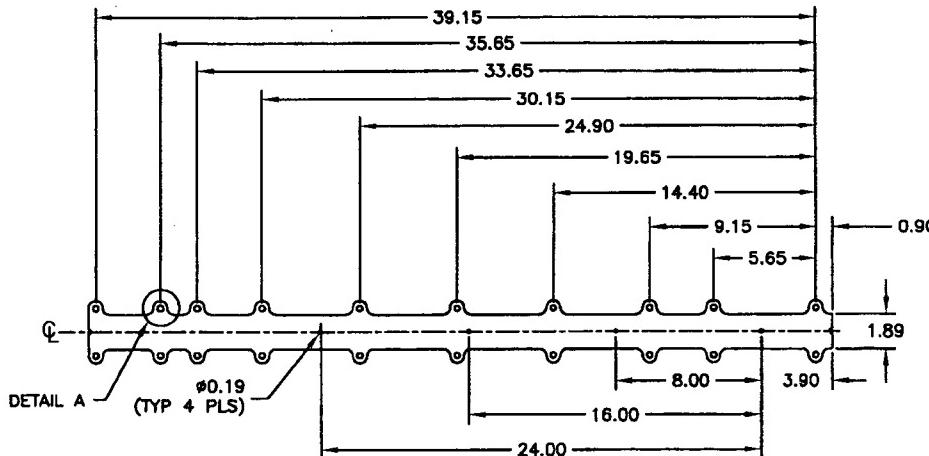
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NOTES

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- 2) FINISH: NONE
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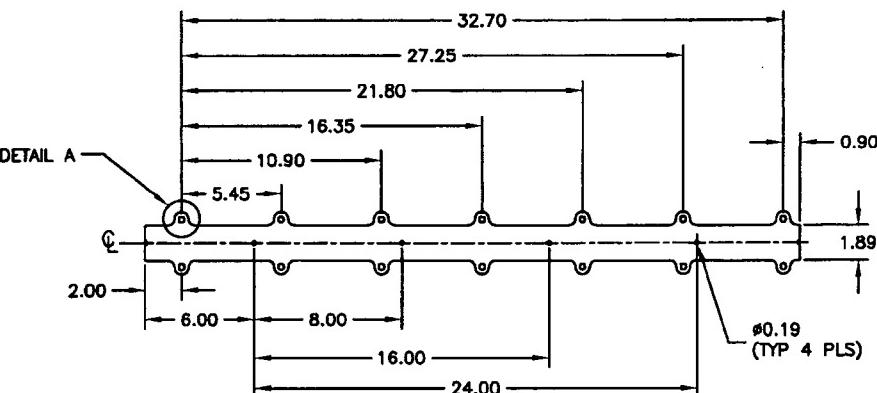


D3536-15 GASKET

RELEASER
07-02-12

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D3536-21 GASKET

7336

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

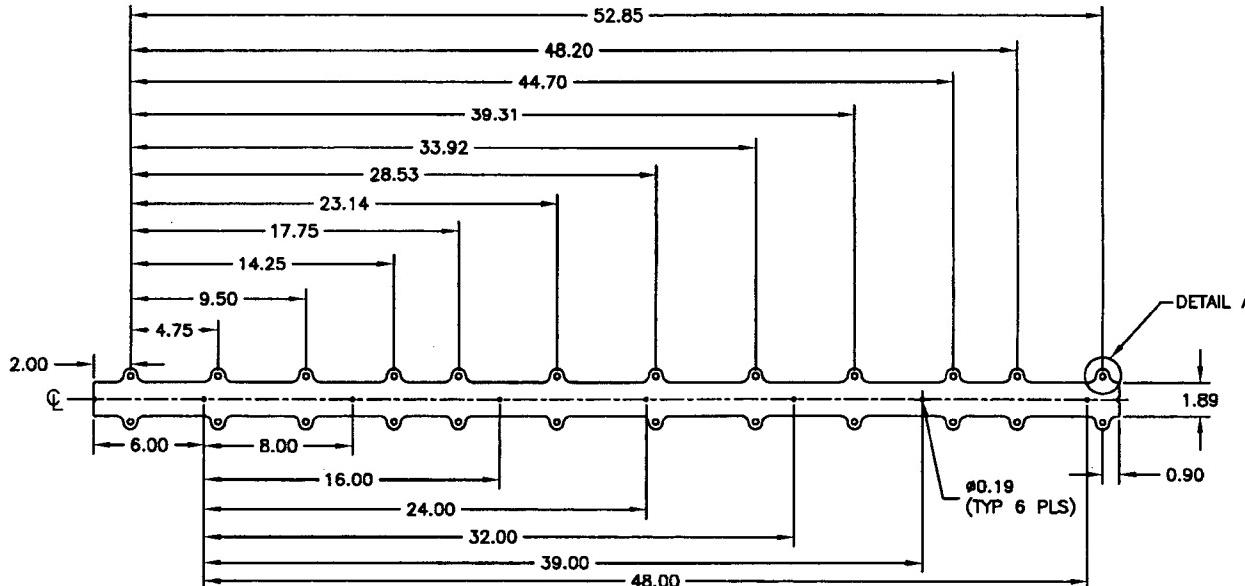
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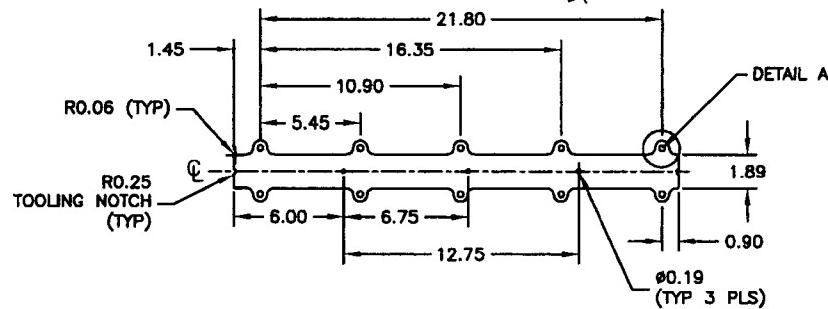
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D3536-23 GASKET



D3536-25 GASKET

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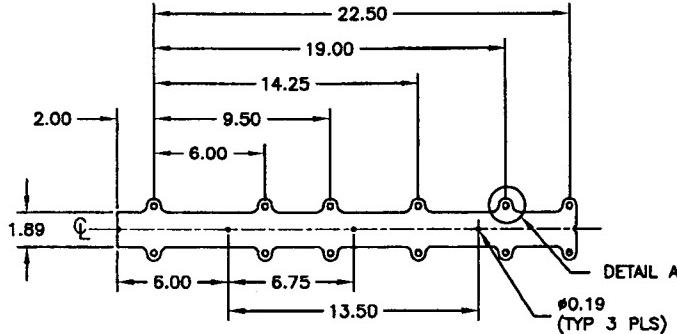
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

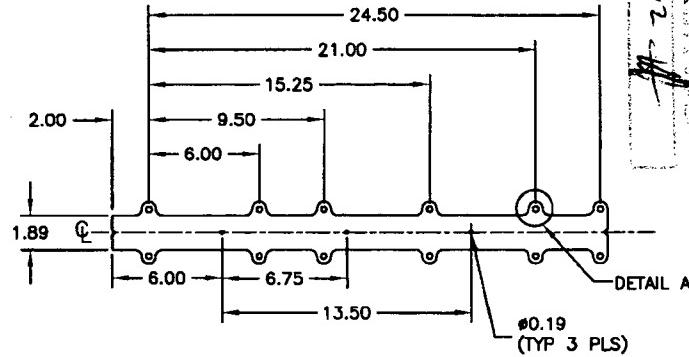
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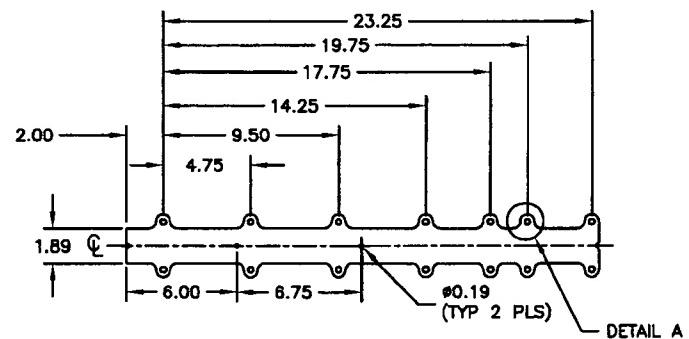
D3536-31 GASKET



D3536-33 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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D3536-35 GASKET

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07.02.12 - PH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

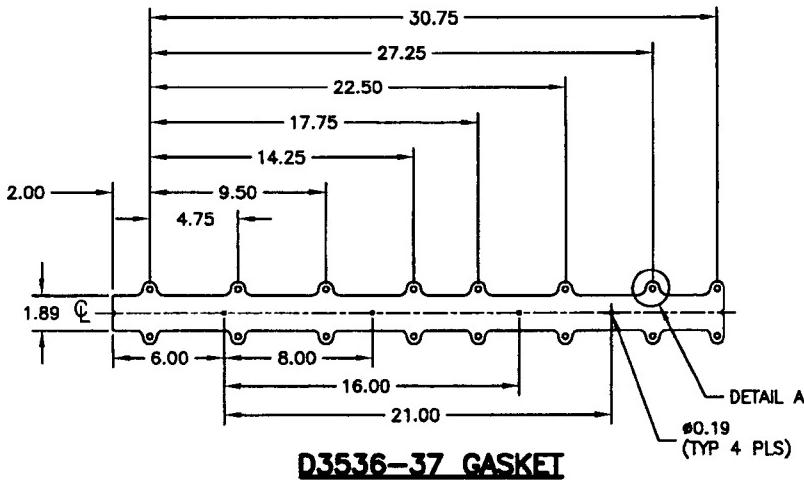
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DATE 06.10.25		TITLE GASKET

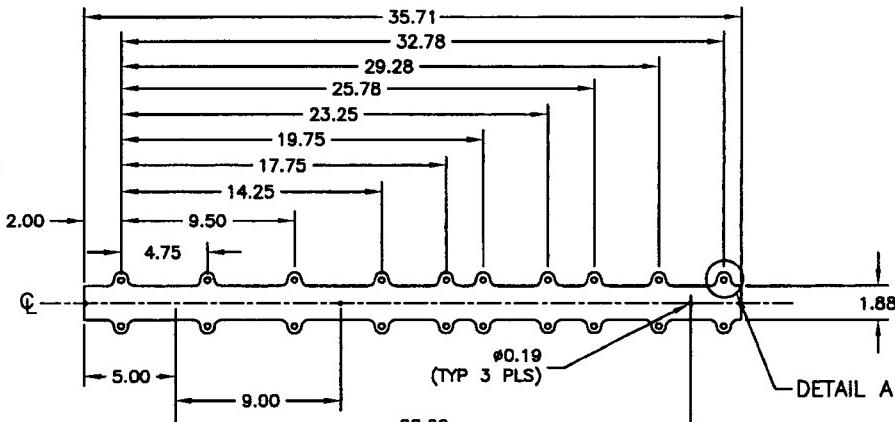
07.02.12 *[Signature]*



D3536-37 GASKET

NOTE:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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D3536-39 GASKET

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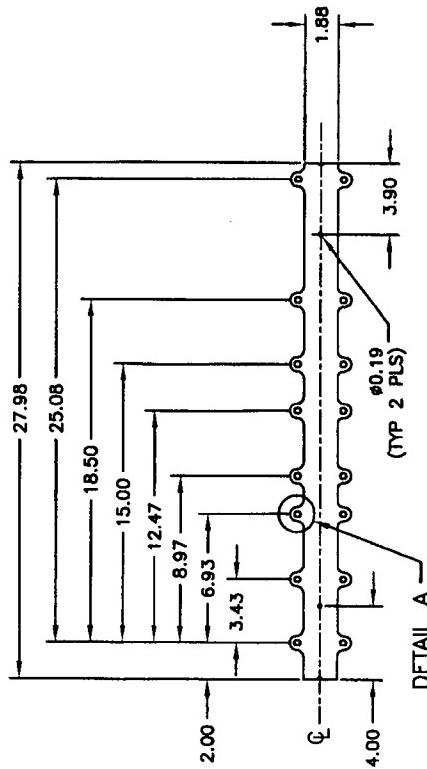
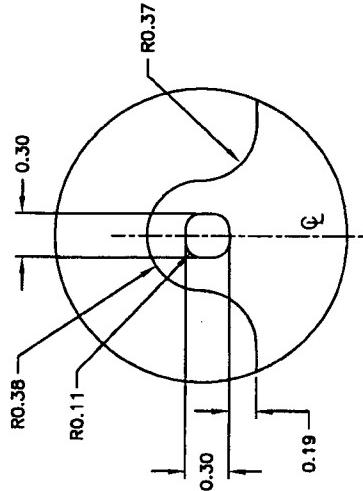
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CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. D3536	REV. A SHEET 6 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10

07.02.12 *[Signature]***D3536-41 GASKET****DETAIL A**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
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